

Work Order ID 134046

Thursday, June 25, 2015 12:35:45 PM

134046

Page 1

Item ID: D2617-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Spacer
Start Date: 6/25/2015 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 6/25/2015 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: MLS Date: JUN 25 2015 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2617	Rev D2								

100

100

Hardinge

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL

Memo

1-Machine as per Folio FA438 and Dwg D2617
2-Deburr

0.00

0.00

100J.C. L. 15/06/29

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

100J.C. L. 15/06/29

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

100J.C. L. 2015-06-29

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
Hand Finish	Memo	0.00							
Hand Finishing									
140	QC7-Inspect Chemical Conversion Coat	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: <u>510080</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									

(10) 15-7-15

(10) 1507-15 DAS 9 9-89

(10) 27 9-89

JUL 20 2015

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MLJ JUL 20 2015

MLJ JUL 20 2015

Picklist Print

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Parent Item: D2617-5

D2617-5

Parent Item Name: Spacer

Start Date: 6/25/2015

Required Date: 6/25/2015

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP H04.07.14Reformat; added step 5KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.500W.058		Purchased	No			100	f	181.8800	0.0195	1			

M6061T6T0 500W 058

6061-T6 RD Tube .500 x.058W

Location

Loc Qty

Loc Code

MAT

19

m131660

19

MAT013

162.88

m130355

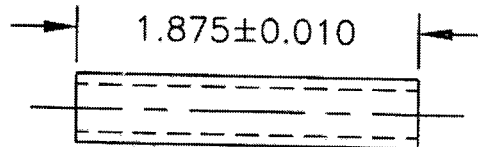
162.88

0.422' J.C.-L. 6/25/2015

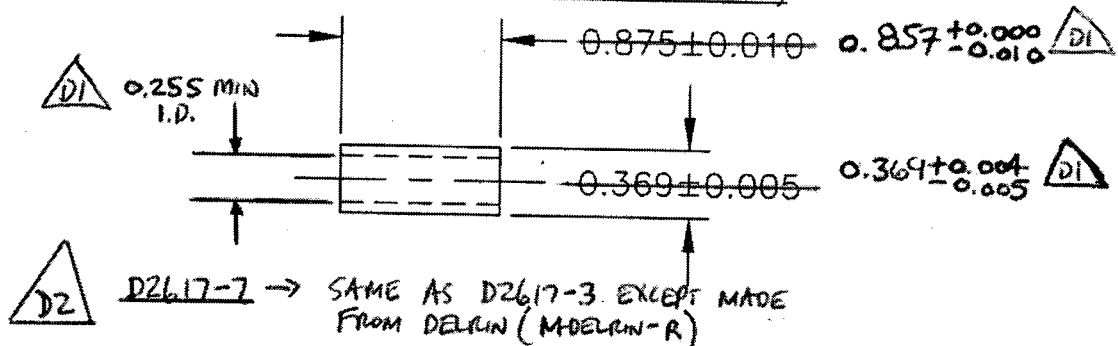


DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD	
HAWKESBURY, ONTARIO, CANADA		CHECKED	#	APPROVED	#
DATE		DRAWING NO.		REV. D	
01.07.04		D2617		SHEET 1 OF 1	
TITLE		BUSHING		SCALE	
01.07.04		BUSHING		1:1	
A		96.10.08		NEW ISSUE	
B		97.05.08		.875 WAS 1.125	
C		97.06.04		0.369 DIA WAS 0.375	
D		01.07.04		ADD MAT'L SPEC AND TOL./DIM. NOTE	
D1		CP		CORRECT TOLERANCE (NCR 779)	

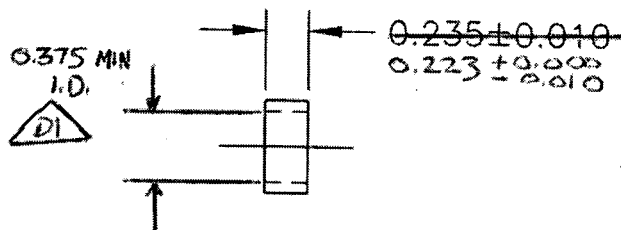
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED
01.07.05

SHOP COPY
RETURN TO
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WITHOUT NOTICE
134046.405
50621

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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